

Date: 5/4/2006 Wednesday, 1/4/2006 2:36:38 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206L BASKET BASE	
Job Number	: 25389A		Part Number	: D2252041	
Estimate Number	: 11273		Drawing Number	: UNDER REVIEW D2252 REV. E	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 1/4/2006 S.O. No. : N/A		Drawing Revision	: E	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/30/2006	
Previous Run	: 23136A		Qty:	1 Um: Each	
Written By	: See COMMENT Below				
Checked & Approved By	: See ABOVE, USER & DATE				
Comment	: Est Rev:1 Revised as per Rev E 05-12-06 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop
Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s) Pick: Qty Part# Description Batch 5 D3166-1 Hoop B25844		
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s) 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M100083		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Cut 5 D2235-1 From D3166-1		
2- Cut Ribs as per Dwg D2252		
3-Drill hole in D2252-1as per Dwg D2252		
4-Deburr & Remove all Markings from Material		

4.0	D22531	Lug
 Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2253-1 Gusset B12413		
2		
3		
4		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/4/2006 2:36:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 25389A

Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D23273 Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2327-3	Bushing	<u>B24874</u>

(1)

AA 06/03/08

6.0 D2581 Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2581	Mounting Chanel	<u>B25834</u>

(H)

AA 06/03/13

7.0 D2254 Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2254	Lug	<u>B23421</u>

(2)

AA 06/03/08

8.0 D22323 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-3	HINGE	<u>B24527</u>

(2)

AA 06/03/08

9.0 D22531 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2253-1	LUG	<u>B24527</u>

(2)

AA 06/03/08

10.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty	Part Number	Description	Batch
32 sf	M304EX0.75-16F	Expanded Metal	<u>M100230</u>

(3)

AA 06/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes Yes No No DQA: DS Date: 04/03/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



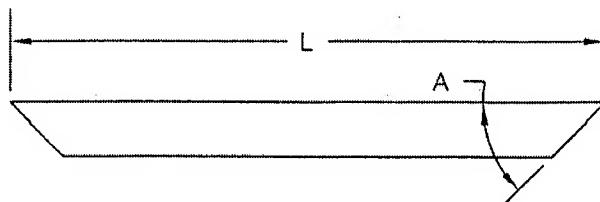
DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2252	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS
C	95.12.11	RE-DRAWN	
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19	

RELEASED
05.11.26 *#*

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

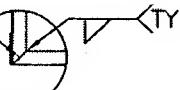
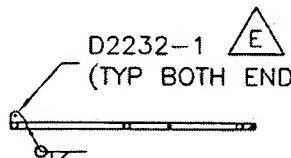


CUT SIZE DETAIL

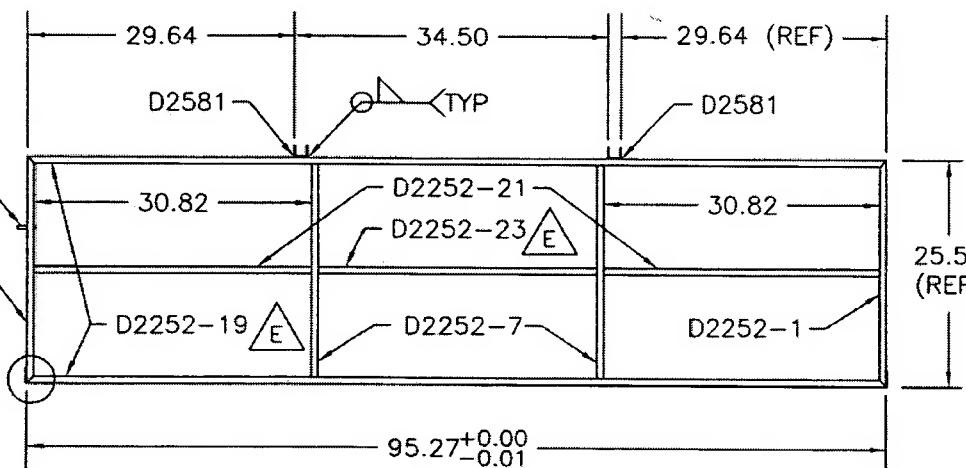
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLER COPY
BUILD
25389 A

Copyright © 1994 by DART AEROSPACE LIB

Copyright © 1994 by DART AEROSPACE LTD



WELD ALL JOINTS
AS SHOWN



D2252-043 LID FRAME

25389

RE
RELEASED
05.11.26
H

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD.	
CHECKED		MB		HAWKESBURY, ONTARIO, CANADA	
APPROVED		W		REV. E	
DATE		DRAWING NO.		SHEET 2 OF 5	
05.11.10		D2252		SCALE	
		TITLE		NTS	
		BASKET ASSEMBLY (206L)			

RELEASER
05-11-26
A

RELEASE
05-11-26

WELD ALL JOINTS
AS SHOWN

A diagram showing a circle with a shaded sector. A triangle is inscribed within this sector. The triangle's base is on the circle's circumference, and its vertex is inside the circle. The angle at the vertex of the triangle is labeled 'TYP' with a leader line.

D2232-3
(REF)

D2252-9

D2235-1
(REF)

D2252-17 (4)

WELD D2581
WITH LARGE HOLE
ON THIS SIDE

WELD D2581
WITH LARGE HOLE
ON THIS SIDE

Technical drawing showing a cross-section of a structural component. The top horizontal dimension is 59.25. The right vertical dimension is 0.75. The left vertical dimension is 25.50 (REF). The top horizontal width is 10.25 (REF) + 25.00 (REF) + 42.00 (REF) + 15.00 (REF) = 92.25 (REF). The bottom horizontal width is 30.00 + 34.50 + 30.00 (REF) = 94.50 (REF). The drawing includes labels D2253-1, D2254 (2 PLACES), D2252-1, D2252-3, D2581, and TYP. Reference lines F and -1 are also indicated.

→ B → C → D

Technical drawing showing a component with the following dimensions and part numbers:

- Overall width: 96.00±0.01
- Width of the central section: 84.25
- Width of the right section: 58.50
- Width of the left section: 15.75
- Bottom width: 87.71
- Height of the left section: 5.50
- Part numbers: D2235-1, D2252-13, D2252-11, D2252-15, D2581, and TYP
- Labels: B, C, D, and E are positioned below the drawing, likely indicating specific features or points of reference.

D2252-041 BASKET FRAME

Copyright © 1994 by DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 1994 by DART AEROSPACE LTD

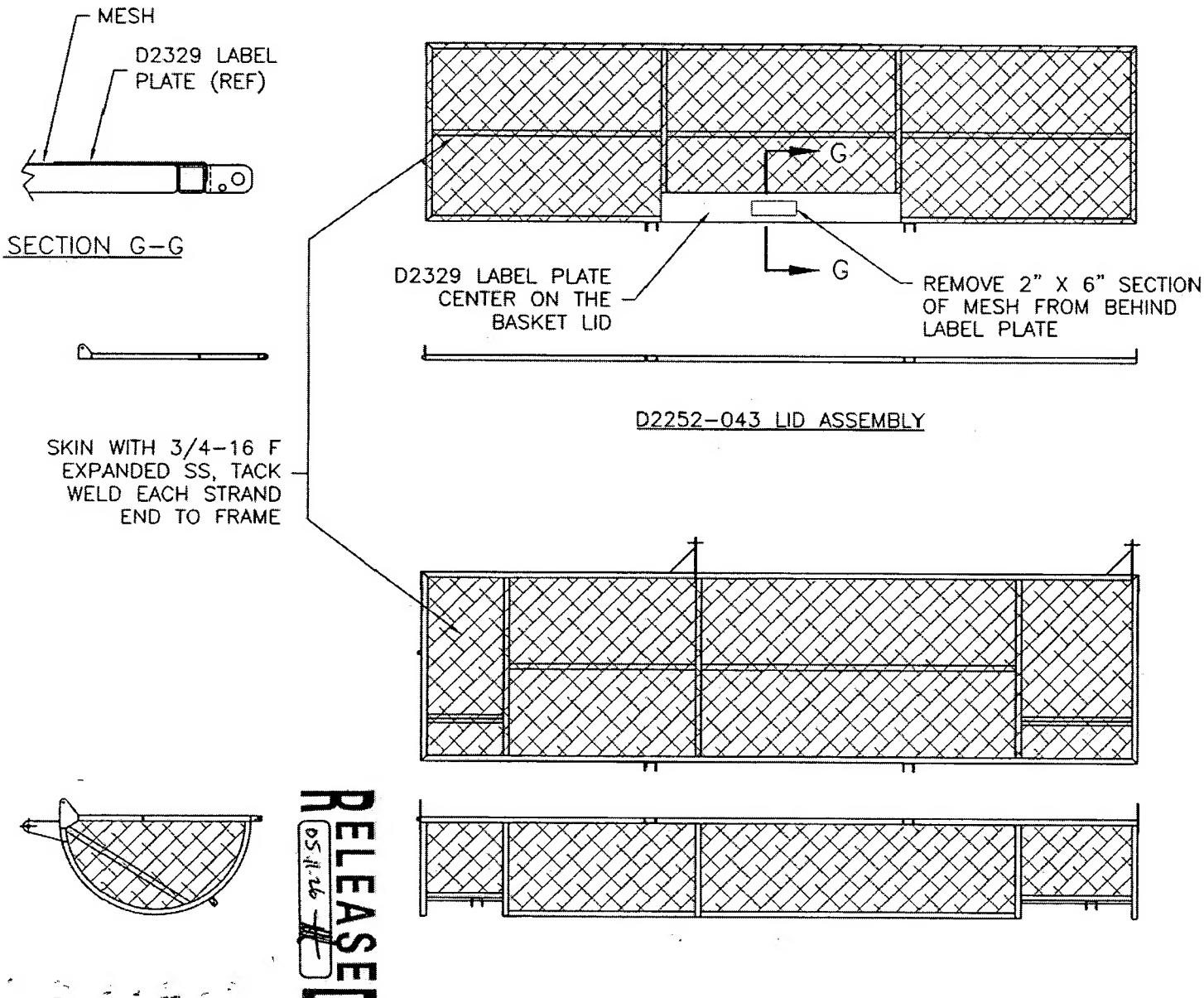
DART

CHECKED	APPROVED	DRAWING NO.	DART AEROSPACE LTD	
			DESIGN	HAWKESBURY, ONTARIO, CANADA
KE	MB	DRAWN BY	REV. E	
DATE	TITLE		SHEET 3 OF 5	SCALE
05.11.10	BASKET ASSEMBLY (206L)		NTS	

DART

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>W</i>	APPROVED <i>W</i>	DRAWING NO. D2252
DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	REV. E SHEET 4 OF 5 SCALE N/A

RELEASED
05.11.10
1.00 REV. E
1.00 PERTAINING
1.00 CONTROLLED COPY
1.00 AMENDMENT
1.00 NOTICE
1.00 ORDER
25389A



THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 1994 by DART AEROSPACE LTD

DART

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	REV. E DRAWING NO. D2252
DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	SHEET 5 OF 5 SCALE N/A

